

Work Order ID 155136

155136

Page 1

Monday, January 09, 2017 11:28:49 AM

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: URF 16-567 Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 6/1/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/3/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **JAN 12 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2273	L U/R M 17/01/12								
D350-604-041	C U/R 17/1/10								
100	Document Control	0.00							
100	DOCUMENT CONTROL					DAS 28 9-89		JUL 03 2017	
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-604-041 CHG 009 CHG 010 DAS 21 9-89 See attachment								
110	PURCHASING	0.00							
110								JAN 17 2017	DAS 13 9-89 27 9-89
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 34973 Description: D350-604-041 Rear locker extender. Manufacture as per dwg D2273 Supplier: FDC Composites Inc. Certification of Conformity and process sheet required. ***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** ***MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 155136***155136***

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Monday, January 09, 2017 11:28:49 AM

Item ID: D350-604-041

Accept

N1900040100Setup Start ***NS1***

Revision ID: URF 16-567

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 6/1/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.								
	DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	Memo	0.05							
Small Fab	1- INSTALL DECALS AS PER DWG								

1x 8017-6-23

① 17-06-23

DAS
9
9-89DAS
28
9-89

JUL 03 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Work Order ID 155136***155136***

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Monday, January 09, 2017 11:28:49 AM

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-567 Stop ***NS2***
Item Name: Rear Locker Extender
Start Date: 6/1/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

150

QC

Memo

0.00

Quality Control

DAS
27
9-89
JUL 03 2017

155	Pick Kit	0.00							
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155

Packaging

Memo

0.00

Packaging

DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM

DAS
27
9-89
JUL 03 2017

158	QC4- 100% Inspect kits for completeness	0.00							
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158

QC

Memo

0.01

Quality Control

DAS
28
9-89
JUL 03 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 155136***155136***

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Monday, January 09, 2017 11:28:49 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-567

Item Name: Rear Locker Extender

Stop

NS2

Start Date: 6/1/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/3/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

*fs 106*DAS
28
9-89DAS
27
9-89

JUL 03 2017

17/7/4

170

0.00

170

QC21- Final Inspection - Work Order Release

QC

Memo

0.02

Quality Control

DAS
21
9-89

JUL 03 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, January 09, 2017 11:28:52 AM

Page 1

Work Order ID: 155136

155136

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 6/1/2017

Required Date: 7/3/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and
washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-604-041P		Purchased	No			110	Each	0.0000	1	1			
D350-604-041P									**				
Rear Locker Extender													
D2268		Manufactured	No			140	Each	13.0000	1	1			
D2268									**				
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		13							
				147069		7		6/13/2017					
				148553		6		7/22/2017					
D2728-1		Manufactured	Yes			140	Each	-1.0000	1	1			
D2728-1									**				
Dart Label Small													
D2269		Manufactured	No			155	Each	8.0000	1	1			
D2269									**				
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		8							
				147070		2		6/13/2017					
				148588		6		7/22/2017					

1x 2017-6-23

B162753 DAS 27 9-89

DAS 28 9-89

DAS 27 9-89

DAS 28 9-89

DAS 27 9-89

DAS 28 9-89

JUL 03 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

Picklist Print

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Page 2

Work Order ID: 155136

155136

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 6/1/2017

Required Date: 7/3/2017

Start Qty: 1.00

Required Qty: 1.00

D5062-041

Manufactured No

155

Each

16.0000

1

1

D5062-041

Bracket Assembly

**DAS
27
9-89**

Location

Loc Qty

Loc Code

ST147

16

145920

16

**DAS
28
9-89**

JUL 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

TABLE 1

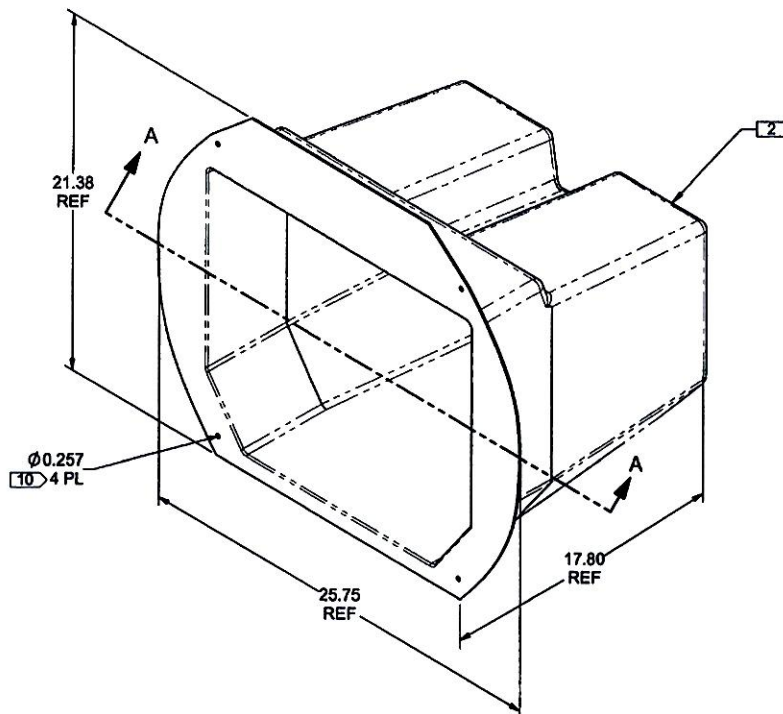
POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

NOTES:

- 1) MATERIAL: SEE TABLE 3
 2) FINISH: SEE TABLES 1, 2, & 3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 5.5 - 7.5 lbs
 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
 9) LAYUP USING DT8871 MOLD. WET LAYUP WITH BAG/VACUUM
 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257
 11) CONSTRUCTION: SEE TABLES 1 & 2
 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	55X3535 WHITE GELCOAT
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4503-PB-23G (GREEN)

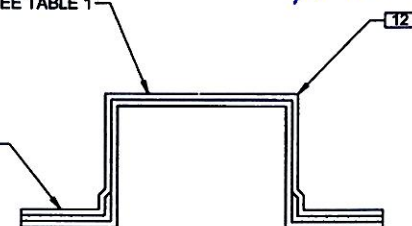
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT

WITHOUT NOTICE
 WORK ORDER

NO. 155136 MLJ
 1701-12

SEE TABLE 1

SEE TABLE 2



SECTION A-A

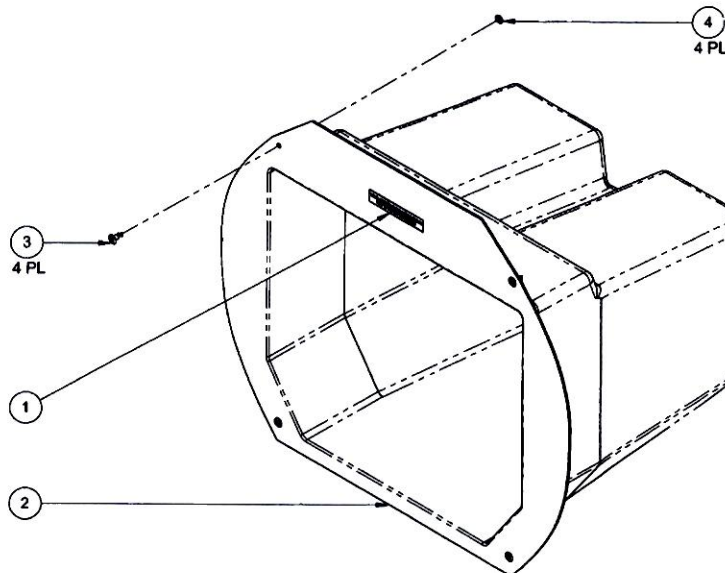
M	CHANGE GELCOAT TO 55X3535 WHITE GELCOAT, REMOVE PAINT FINISH OPTION (NOTE 2)	DB	18.05.19
L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MAT'L PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A8-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. M
MFG. APPR.	DD	D2273	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	350 REAR LOCKER EXTENDER	NTS
DATE	16.05.19	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
 2017-01-11
 ECU 17-501

APPROVED

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
1	1	D2268	PLACARD
2	1	D2273	REAR LOCKER EXTENDER
3	4	2600-6	CAMLOCK STUD
4	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 5.5 to 7.5 lbs
- 8) INSTALL D2268 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

C	REMOVE D2728-1, D2729-1 DECALS (ZN C5-1) REVISED RELATED NOTES, UPDATED PART WEIGHT	ML	13.12.16
B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS. ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1). ADD D2729-1 (ZN C5-1).	UC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D350-604-041	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RLE ASSY	NTS
DATE	14.01.02	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-604-041

Description: REAR LOCKER EXTENDER

[illegible]

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER
Purchase Order ID PO34973

Purchase Order Date 1/17/2017 9:02:37 AM
PO Print Date 1/31/2017

Page Number 2 of 3

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344 ext303
Ship To Contact
Ship To Phone
Ship Via: Journey Freight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	D350-604-041P	Rear Locker Extender	6/5/2017	1.00	\$705.00	\$705.00
			Yes	Each		
			6/5/2017			

AS PER DWG D2273 REV. M / D350-604-041 REV. C
B155135
PLEASE NOTE REARLOCKER UNDER NEW REV. M

Line Total: \$705.00

4	D350-604-041P	Rear Locker Extender	6/5/2017	1.00	\$705.00	\$705.00
			Yes	Each		
			6/5/2017			

AS PER DWG D2273 REV. M / D350-604-041 REV. C
B155136
PLEASE NOTE REARLOCKER UNDER NEW REV. M

DAS
9
9-89

8217-6-23

Line Total: \$705.00

5	D350-604-041P	Rear Locker Extender	6/5/2017	1.00	\$705.00	\$705.00
			Yes	Each		
			6/5/2017			

AS PER DWG D2273 REV. M / D350-604-041 REV. C
B155137
PLEASE NOTE REARLOCKER UNDER NEW REV. M

PO Instructions: NOTE: NO BILLING PRIOR TO SHIPPING

Note:

1/31/2017

#128

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel.: 450 357-1344

Shipping Order

15/06/2017

Order : 2640
Reference : PO 34973/1-5

Customer: Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To
DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivere	B/O Qty
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/1 Lot: 2017-02-22 As per DWG.D2273 Rev. M B155133	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/2 Lot: 2017-02-27 As per DWG.D2273 Rev. M B155134	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/3 Lot: 2017-03-02 As per DWG.D2273 Rev. M B155135	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/4 Lot: 2017-03-06 As per DWG.D2273 Rev. M B155136	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 34973/5 Lot: 2017-03-08 As per DWG.D2273 Rev. M B155137	1		

Shipping :
Package No :
Merchandise Received :

Ref. :
:
:



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 34973

Revision: NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155133	DAE001-111	2017-02-22
2	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155134	DAE001-118	2017-02-27
3	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155135	DAE001-126	2017-03-02
4	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155136	DAE001-128	2017-03-06
5	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B155137	DAE001-135	2017-03-08

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: Marjorie
Marjorie Geoffrion, Quality Inspector

Date: 2017-06-16



# LOT	2017-01-06-01-06
# SÉRIE(ID)	DAE001-128

ID: B155136/4

Nom de Gamme :	Rear locker extender – DART
# de Gamme (et rev.) :	DAE001 Rev. E
Nom pièce – Client :	350 Rear locker extender – DART AEROSPACE
# de Dessins (et rev.) :	D2273 Rev. M

Fiche suiveuse

[10-50]	PRÉPARATION	Moule, Espace de travail, Matières premières, Consommables	#21 01 MAR. 2017
[60-80]	FINITION	Appliquer Gelcoat, Inspecter	#3 06 MAR. 2017
[90-140]	MOULAGE	Laminer, Démouler, Inspecter	#19 #23 06 MAR. 2017 06 MAR. 2017
[150-190]	USINAGE	Percer, Découper, Ébavurer, Inspecter, Sabler	#25 #21 06 MAR. 2017 06 MAR. 2017
[200-230]	FINITION	Primer, Inspection	#30 9 MAR. 2017
240	EXPÉDITION	Emballer, Expédier	#3 28 MAR. 2017
			#8 15 JUIN 2017

Gamme préparée par :	Guillaume G.Jasmin
Gamme vérifiée par :	Francis Lavigne-Larente
Gamme approuvée par :	Maxime Gagné
Date d'émission :	2015-01-14

Gamme révisé préparée par :	Pascal Séguin
Gamme révisé vérifiée par :	Karim Malihi
Gamme révisé approuvée par :	Michel Morin
Date de révision :	2017-02-22

Informations à remplir :
Cases grises pâles

Inspection :

Approbation Qualité
Avant de produire le CofC, toutes les étapes et les informations requises des gammes subséquentes reliées à ce produit ont été complétées et remplies



Matières premières

Résine	1028612	2017-05-17	Dion 7704
Norox (Résine)	41049	2017-08-01	MEKP-9
Norox (Gelcoat)	41049	2017-08-01	MEKP-9
Gelcoat blanc	702284	2017-08-20	55X-3535
Mat ¾ oz/pi²	15851100174-1	N/A	¾ oz Chopped Strand Mat (Owens Corning Or Equivalent)
Fibre de verre 7725	4451515	N/A	Hexcel 7725 Fiber Glass
Apprêt (Primer) (Vert)	18584	2018-02-31	Tempo 4500-PB-23G (Vert)
Durcisseur pour apprêt (hardener)	18317	2018-05-01	Tempo 4500-C-23
Attache mécanique (Camloc)	1745658	N/A	2600-5
Rondelle de retenue pour Camloc	508980	N/A	2600-LW

Moule : MOU306 ou MOU309	FMS	Sarrau
Pompe à vide	55NC	Lunettes de sécurité
Jig de découpe et perçage CNC 5 axes	Peel ply	Soulier de protection
Jig de finition et d'inspection : GAB355	Film perforé	Gants
	Bleeder breather	Masques à cartouches
Pince pour installer Camloc : OUT951	Bag big blue	
Outil pour installer rondelle de retenue : OUT952	Ruban scellant (Dum Dum)	

Annexe 1
Formulaire de résine (RES-DAE001)

MPS-300-93-31-007-NC	Démoulage 55NC
MPS-300-93-31-058-A	Composite part inspection
MPS-300-93-31-020-B	Edge finish after trimming
MPS-300-93-31-097-NC	Epoxy - Polyamide primer
MPS-300-93-31-084-NC	Protection et entreposage des pièces

Suivi des révisions

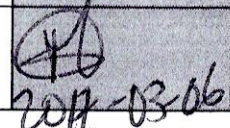
A	Révision d'une OP inspection, Ajout nouveaux moules et retrait d'un type de primer	2015-03-04	Guillaume G.Jasmin
B	Ajout des conformateurs, du gabarit GAB355, de l'installation des camlocs, inspection du poids et identification finale	2015-03-25	Guillaume G.Jasmin
C	Mise à jour de la case approbation qualité page 1	2015-04-02	Guillaume G.Jasmin
E	Changement de gelcoat, modification du format de la gamme, révision complète de la gamme	2017-02-22	Pascal Séguin

PRÉPARATION

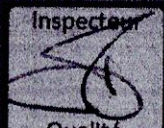
10	<u>Remplir les informations requises sur la première page (cases gris pâle)</u> - Demander au coordonnateur de production (ID) - Inscrire les heures et les dates d'entrée et de sortie de département		- 1 MAR 2017 #23 01 MAR 2017	E: R:
20	<u>Découper la fibre et les périssables (Peel ply, sac étanche...) selon l'ANNEXE 1</u> - ACHEMINER et REMPLIR la section « Matière premières » pour : - Fibre de verre 7725 - Mat ¾ oz	Annexe 1	- 1 MAR 2017 #23 01 MAR 2017	E: R:
30	<u>Préparer la résine selon RES-DAE001 (Gamme de formulation de résine)</u> ACHEMINER et REMPLIR la section « Matière premières » pour : - Résine - Norox	RES-DAE001	#28 6 MAR 2017	E: R:
40	<u>Péparer le moule</u> - Cochez le moule utilisé : MOU306 ☒ / MOU309 ☐ ☐ Nettoyer et traiter le moule ☒ Poser le Masking tape <u>Si nécessaire, traiter le moule au 55NC</u> Faire le test de pelage, s'il ne passe pas, appliquer une couche de 55NC et refaire le test.	Annexe 1 MOU306 ou MOU309 MPS-300-93-31-007	#21 03 MAR 2017	R:

50	<u>Préparer l'espace de travail (pendant l'application du gelcoat)</u>		#21 03 MAR 2017 #23 03 MAR 2017	E: R:	
	☒ Vérifier et préparer la pompe ☒ Préparer et distribuer les outils ☒ Protéger l'environnement de travail (tables, plancher, etc.) ☒ Vêtir l'équipement de protection personnel ☒ Partir la ventilation ☒ Vérifier l'ordre et la présence de tous les plis de fibre et des morceaux de noyau dans le sac				
	Position	Matériel			Initial employé
	10F	¾ oz Chopped strand MAT			<i>Plavin</i> <i>NY</i>
	20F	7725 Fibre de verre			<i>Plavin</i> <i>NY</i>
	30F	7725 Fibre de verre			<i>Plavin</i> <i>NY</i>
	40R	7725 Fibre de verre			<i>Plavin</i> <i>NY</i>
	50R	7725 Fibre de verre			<i>Plavin</i> <i>NY</i>
	60R	7725 Fibre de verre			<i>Plavin</i> <i>NY</i>
	70F	7725 Fibre de verre			<i>Plavin</i> <i>NY</i>

FINITION

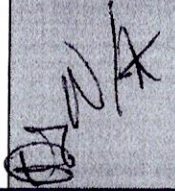
60	<u>ACHEMINER et REMPLIR la section « Matière premières » pour :</u> • Gelcoat blanc 55X-3525 • Norox MEKP-9		#28 6 MAR 2017	E: R:
70	<u>Appliquer le Gelcoat (18 - 23 mils)</u> Heure d'application 0.6 h 15 min	Annexe 1	05 MAR 2017	R:
80	<u>Vérification de l'épaisseur du gelcoat lorsqu'encre humide</u>	Gauge d'épaisseur		E: R:

MOULAGE

MOULAGE																			
			Inspecteur  Qualité																
			20703-06																
	LAMINER																		
	<table border="1"> <thead> <tr> <th>Position</th> <th>Matériel</th> </tr> </thead> <tbody> <tr> <td>10F</td> <td>¾ oz Chopped strand MAT</td> </tr> <tr> <td>20F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>30F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>40R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>50R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>60R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>70F</td> <td>7725 Fibre de verre</td> </tr> </tbody> </table>	Position	Matériel	10F	¾ oz Chopped strand MAT	20F	7725 Fibre de verre	30F	7725 Fibre de verre	40R	7725 Fibre de verre	50R	7725 Fibre de verre	60R	7725 Fibre de verre	70F	7725 Fibre de verre		
Position	Matériel																		
10F	¾ oz Chopped strand MAT																		
20F	7725 Fibre de verre																		
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40R	7725 Fibre de verre																		
50R	7725 Fibre de verre																		
60R	7725 Fibre de verre																		
70F	7725 Fibre de verre																		
100	CONSOMMABLE <table border="1"> <tbody> <tr> <td>10F</td> <td>Peel Ply</td> </tr> <tr> <td>20F</td> <td>Release film non perforé</td> </tr> <tr> <td>30F</td> <td>Bleeder / Breather</td> </tr> <tr> <td>50F</td> <td>Bagging bleu</td> </tr> </tbody> </table> ☐ S'assurer que tous les plis dans le tableau ont été laminés ☐ S'assurer que tous les conformateurs (Qte 9) sont en place par-dessus le Bleeder/Breather <table border="1"> <tbody> <tr> <td>Heure début laminage</td> <td>7 h 15 min</td> </tr> <tr> <td>Heure mise sous-vide (sac scellé)</td> <td>8 h 15 min</td> </tr> <tr> <td>Intensité du vide (25 inHg)</td> <td>29</td> </tr> </tbody> </table>	10F	Peel Ply	20F	Release film non perforé	30F	Bleeder / Breather	50F	Bagging bleu	Heure début laminage	7 h 15 min	Heure mise sous-vide (sac scellé)	8 h 15 min	Intensité du vide (25 inHg)	29	Annexe 1 GAB356 à GAB364 (Qte 9)	#23 06 MAR 2017 #19 06 MAR 2017 #26 06 MAR 2017 #21 06 MAR 2017		
10F	Peel Ply																		
20F	Release film non perforé																		
30F	Bleeder / Breather																		
50F	Bagging bleu																		
Heure début laminage	7 h 15 min																		
Heure mise sous-vide (sac scellé)	8 h 15 min																		
Intensité du vide (25 inHg)	29																		
110	#26 LAISSER POLYMÉRISER la pièce sous vide pendant 2h 06 MAR. 2017	#19 06 MAR. 2017	#23 N/A 06 MAR. 2017 E: 06 MAR. 2017 R:																
120	<u>DÉMOULER et IDENTIFIER la pièce</u> ☒ Brancher le système d'air comprimé ☒ Écrire le numéro de pièce et la date sur un collant – # de lot (date de début) – # de série ID Ex : (AAAAMMJJ) – (DAE001-XXX) ☒ Placer la pièce sur la table d'inspection	Annexe 1	#19 06 MAR. 2017 #26 06 MAR. 2017 E: R:																

130				Inspecteur Qualité
140	<u>Nettoyer le moule</u> - Enlever la résine durcie tout le tour du moule avec une spatule en plastique pour ne pas endommager le moule <u>Si nécessaire</u>, nettoyer le moule avec un chiffon légèrement humecté de nettoyant à moule (PMC) NE PAS TROP APPLIQUER DE "PMC"	Spatule en plastique	#19 06 MAR. 2017	E: R:

USINAGE

150	<u>PERÇAGE ET DÉCOUPE CNC 5 axes :</u> Utiliser le gabarit d'usinage et le programme d'usinage à l'emplacement suivant : Z:\PROGRAMMES\Dart Aerospace\Dart Aerospace Rear Lockers\21-Dessins & Outillage\Outillage\usinage 5 axes	Annexe 1	#30 9 MAR. 2017	E: R:
160	<u>SABLAGE :</u> - INSTALLER le Gabarit de finition et d'inspection GAB355 - SABLER la pièce jusqu'à arriver à la dimension du Gabarit GAB355 - ÉBAVURER les arêtes vives	GAB355 Annexe 1 MPS-300-93-31-020		E: R:
170			Inspecteur Qualité	
180	SABLER légèrement l'extérieur de la pièce Papier 120 à 320 grains		#19 14 MAR. 2017	E: R:
190	NETTOYER les surfaces extérieures		#19 14 MAR. 2017	E: R:

FINITION

200	APPLIQUER le primer 2 couches d'environ 10 mils chacune	MPS-300-93-31-097	#5 MARS 28 AVR. 2017	E: R:
210	<u>Protéger le gelcoat</u> Découper une pellicule de plastique protecteur bleu et la coller sur le rebord et à l'intérieur de la partie blanche (Gelcoat) (Voir Annexe 1)	Annexe 1	2 mai 2017 JMA	E: R:
220	<u>INSTALLER les attaches mécaniques (Camlocs) (Qte 4)</u> - Utiliser les pinces spécialisées (OUT951) pour insérer les Camlocs dans les trous - Utiliser l'outil spécialisé (OUT952) pour installer les rondelles de retenues	Annexe 1 Pince à Camloc (OUT951)	2 mai 2017 JMA	E: R:
230			inspecteur #8 15 JUIN 2017 Qualité	

EXPÉDITION

240	Identifier, emballer et expédier Identification selon le document DART QSI044 à l'emplacement suivant : Z:\PROGRAMMES\Dart Aerospace\Dart Aerospace Rear Lockers\22-Gammes de Fabrication\In process	MPS-300-93-31-084	#8 15 JUIN 2017	E: R:

Work Order ID 155136

Monday, January 09, 2017 11:28:49 AM

155136

Page 1

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 16-567 Stop ***NS2***
Item Name: Rear Locker Extender
Start Date: 6/1/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JAN 12 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2273	LUR M 17/01/12								
D350-604-041	CUR 17/1/13								
100	Document Control	0.00	DAS 27 9-89			DAS 5 9-89			JUL 03 2017
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-604-041 CHG 009 0176010 DAS 21 9-89 See attachment								
110	PURCHASING	0.00							
110	Purchasing	0.00							JAN 17 2017 DAS 27 9-89
Purchasing	Memo Issue P/O: 34973 Description: D350-604-041 Rear locker extender. Manufacture as per dwg D2273 Supplier: FDC Composites Inc. Certification of Conformity and process sheet required.								

EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH90-4

Issue No.: 4

Approval Date: January 31, 1990

Issue Date: February 17, 2012

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Eurocopter France AS 350 B, B1, B2, B3, BA, D
Eurocopter France AS 355 E, F, F1, F2, N, NP

Canadian Type Certificate or Equivalent:

H-83 (AS 350 Series); H-87 (AS 355 Series)

Description of Type Design Change:

Installation of Rear-Locker Extender

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of Rear-Locker Extender must be in accordance with Transport Canada Civil Aviation (TCCA) approved Dart Aerospace Ltd. Installation Drawing D350-604, revision C, dated December 6, 2011 or later TCCA approved revision.

Operation of the Rear-Locker Extender must be in accordance with TCCA approved Dart Aerospace Ltd. Flight Manual Supplement FMS-D350-604, revision B, dated November 15, 2011, or later TCCA approved revision.

Maintenance of the Rear-Locker Extender must be in accordance with TCCA accepted Dart Aerospace Ltd. Instructions for Continued Airworthiness ICA-D350-604, revision 0, dated November 15, 2011, or later TCCA accepted revision.

Definition of Type Design Change: TCCA approved Dart Aerospace Ltd. Master Document List MDL-D350-604, revision A, dated February 2, 2012, or later TCCA approved revision.

Basis of Certification for affected areas: 14 CFR, Part 27 at amendment 27-21.

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.

Greg Oucharek
For Minister of Transport

Canada